

Date: Monday, 02/03/2009 9:08:42 AM  
User: Melanie Fauteux

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END FITTING ASS'Y
Job Number	: 46156		
Estimate Number	: 13345		
P.O. Number	:	Part Number	: D3763041
This Issue	: 02/03/2009 S.O. No. :	Drawing Number	: D3763 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 42952	Material	:
Written By	:	Due Date	: 09/03/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>MF 09-03-02</u>		
Comment	Est Rev:A 08-05-20 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC Est Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

2.0	D37631	End Fitting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
End Fitting  
batch: B42732 = 10x

SP 09-03-19

3.0	D37633	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Tube  
batch: B 42 733 = 10

SP 09-03-19

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
1-make a 0.063" chamfer on D3763-1 fitting before ass'y  
  
2-assemble as per dwg D3763 using locating pin DT9039  
\*\*\*\*\*ensure locating pin is in 0.221" hole\*\*\*\*\*  
  
3-weld as per dwg D3763 QSI004  
Alum. rod Batch: M104855

SP 09-03-19 (10x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/03/2009 9:08:42 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END FITTING ASS'Y

Job Number: 46156

Part Number: D3763041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*ZE 09/03/19 (10)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



*09/03/19 (10)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*CMO/ BR*

*09/03/19*

*(X10)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FE 09/03/19*

*(10)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: *251*

*9/3/20*

*Sq*

*(10K)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*10/09/20*

*(10)*

Job Completion



*10/09/20*

**Dart Aerospace Ltd**

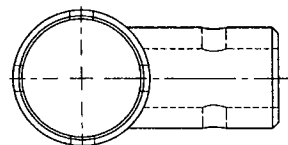
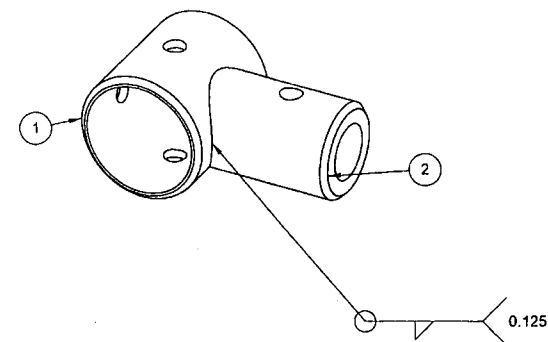
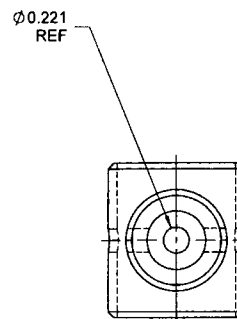
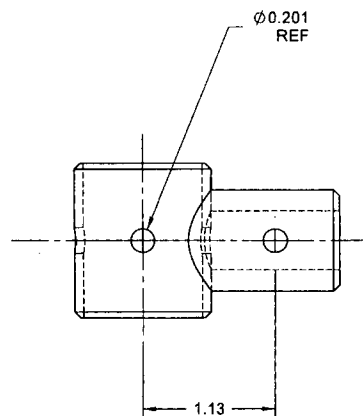
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

# **D3763-041 END FITTING ASSY**

RELEASED

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.03 lbs
  - 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3763	SHEET 1 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	END FITTING	NTS
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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